

Work Order ID 85831

85831

Page 1

Item ID: D2564

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mounting Angle

Start Date: 15/06/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/15

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2564

Rev B1

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030)

12-06-20

20

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA276 Rev: _____ & Dwg D2564 Rev: _____

2- Deburr if necessary

Manual Mill

12-06-20

20

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

12-06-20

20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 85831***85831***

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Item ID: D2564

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mounting Angle

Start Date: 15/06/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: WA

0.00

140

Packaging

Memo

0.00

Packaging

*** STOCK IN STEP CELL ***

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

20

12/06/2012 JB

12/06/2012

ME 12-06-21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

June-15-12 1:34:03 PM

Page 1

Work Order ID: 85831

85831

Parent Item: D2564

D2564

Parent Item Name: Mounting Angle

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP: D02.09.09Re-format; Added FA276 FolioKJ/RF

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6207 | | Manufactured | No | | | 100 | f | 18.2424 | 0.0916 | 1.542737 | | | |

D6207

Angle Extrusion

**

Location

Loc Qty

Loc Code

MAT028

18.2424

72237

18.2424

M6061TB A1.000X W.125

122081

2.0 f 90 12-06-20

| W/O: | | WORK ORDER CHANGES | | | | | |
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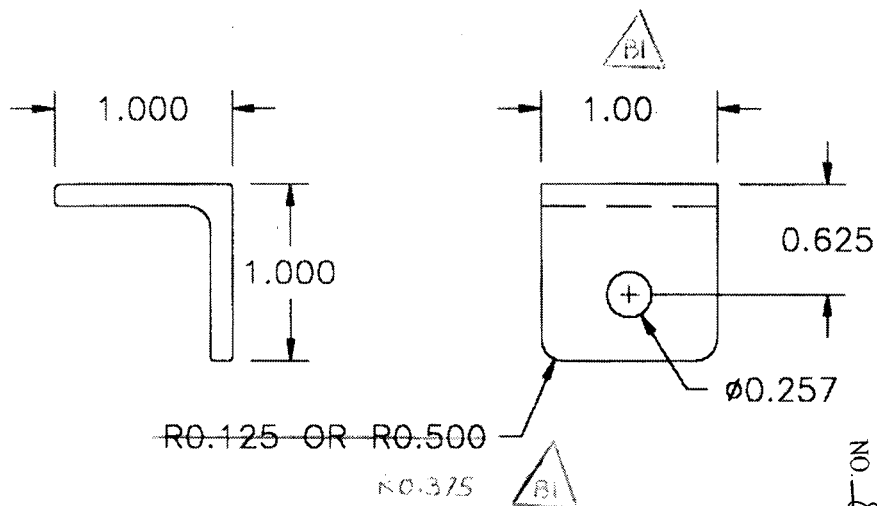
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NOTE: Date & initial all entries



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|----------|----------------|--|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD | |
| MIKE M | MIKE M | VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | REV. B |
| BW | BW | D2564 | SHEET 1 OF 1 |
| DATE | TITLE | | SCALE |
| 96:04:30 | MOUNTING ANGLE | | 1:1 |
| B | 97:05:06 | MODIFIED DIMENSIONS | |
| BI | DATE 02.07.17 | R0.375 WAS R0.125 OR R0.500; 1.00 WAS 1.000 | |

RELEASED
97/05/06 BW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85031 MJS
12/06/15

NOTES

- 1) MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125
MAKE FROM D6207-XXX ANGLE EXTRUSION
- 2) BREAK ALL SHARP EDGES 0.005 R0.015
- 3) TOLERANCES PER DART Q31 Q18 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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